



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4634-043
Job Sheet 202525



Part No: D4634-043

Job Qty: 1 pcs

Part Name: Middle, Center Ceiling Panel Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/30/19

Job Tracking No:

Due Date: 11/15/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D4634 REV.H IPP Rev. A 12/08/09 New Issue DL IPP Rev B 12/11/08 Document release DL VERIFIED
BY:JLM IPP Rev C 13/07/09 Dwg Update DL ver: DD IPP Rev D Dwg Update 13/12/23 DL IPP REV E Dwg
update 14/01/09 DL IPP Rev F Dwg. update 14/02/03 DL IPP Rev G Dwg. Update 15/01/27 DL IPP REV:H
19.05.06 AS PER DWG REV.H DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	11/15/19		0.00	1.00	Small Fab - 1		DAS 68 9-89 NOV 21 2019
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
110	QC 5	1 pcs	11/15/19		0.00	0.00	QC 5 - 10		DAS 68 9-89 NOV 27 2019
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
120	Packaging 3-1 - Stock - B4B	1 pcs	11/15/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		

				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	

130	QC 21 - SA	1 pcs	11/15/19	0.00	0.00	QC 21 - SA - 21	
						QC 21 - SA - 70	DAS 78
						QC 21 - SA - 53	NOV 27 2019

Part Op 100 - Small Fab (Small Fab) ***BEFORE INTALLING D4728-051, APPLY A 3/16" SEEM OF PLASTIC-WELD 2 ON
Descriptions: TOTAL LENGHT OF PART ON EANCH SIDE OF LIGHT, LET DRY FOR ONE HOUR*** PLASTIC-WELD 2 BATCH : 5159491
1- Assemble as per Dwg D4634-043 2- install No Smoking & seat belt symbols 3- Install led lights
4- Install Air valves 5-Install Wiring Harness
110 - QC5 (QC5- Inspect part completeness to step on W/O)
120 - Packaging3 (Identify as per dwg & Stock Location:)
130 - QC21 (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
2351-20-27-C3C	Stud	2 Ea (2 ea)	100-Small Fab - 1	30071846
50-009-2	Grommet	2 Ea (2 ea)	100-Small Fab - 1	30051168
D4634-143	Middle, Center Ceiling Replacement Panel Assembly	1 pcs (1 ea)	100-Small Fab - 1	5229734
D4646-1	Plenum Cap Assembly	2 pcs (2 ea)	100-Small Fab - 1	5188389
D4652-7	Air Valve	2 pcs (2 ea)	100-Small Fab - 1	5124503
D4728-053	Cabin Lights #2	1 pcs (1 ea)	100-Small Fab - 1	516273
PLT1.5M-M	Tie Wrap	3 Ea (3 ea)	100-Small Fab - 1	5 Pm129712

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	2351-20-27-C3C	2	17	0
	50-009-2	2	128	0
	D4634-143	1	0	0
	D4646-1	2	37	0
	D4652-7	2	0	0
	D4728-053	1	9	0
	PLT1.5M-M	3	1,963	0
Part Specifications				
Specifications could not be found.				

Plex 10/30/19 7:57 AM Dart.lajeunesse.marie



NCR No. _____																					
Job: _____		DISPOSITION				DEPARTMENT/PROCESS															
Part No. _____		Rework Scrap Use-as-is				Cross tube Small Fab Finishing				Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging											
Date :		Sequence #:		QTY Affected :		MRB (QSI042)															
Description Work Order Deviation						Disposition						Completed By									
												Lead hand / Supervisor									
												QC / QA Coordinator									
Root Cause						FAULT CATEGORY															
Operator						Pressure/Forced				Contamination				Power Loss/Surge				Positioned Wrong			
Manufacturing Process						Bending				Misaligned/off center				Folio/Program				Outside Tolerance			
Equip/Tooling						Crushing				BOM/Route				Grain Direction				Drawing			
Handling/Preservation						Cracks				Broken/Damage/Defect				Weld				Finish			
Material						Crimp/Kink/Ripple/Wave/Twist				Incomplete/Unclear Instructions				Wrong Stock Pulled				Part Lost/Missing			
Product Improvement						Marks/Chatter				Drill Holes				Out of Sequence				Misread			
Process Improvement						Mislabeled				Fit/Function				Off-set/Set-up							
Human Factors						Other/Details:															